



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5557-1
Job Sheet 184523



Part No: D5557-1

Job Qty: 10 ea

Part Name: Cutter Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: TBD Dwg D5557 Rev.A7 IPP Rev.A New issue 18/01/29 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-4		DIP 18-11-4
110	CNC Vertical Machining	10 pcs	11/2/18	11/2/18	0.00	5.00	HAAS1-1		DIP 18-11-4
120	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-4		DIP 18-11-4
130	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-4		J.C.L. 18-11-04
140	Outsource	10 pcs	11/2/18	11/2/18			MEI001-VC	10	QC 18-11-07
150	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging2		NOV 22 2018
155	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC6		38
160	SprayPaint	10 pcs	11/2/18	11/2/18	0.00	0.05	Spray Paint		AS 18-11-28 DAS
170	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC14		DEC 03 2018 68
180	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2		DEC 03 2018
190	QC21-SA	10 Ea	11/2/18	11/2/18	0.00	0.00	QC21		DEC 04 2018

Part Op 90 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB765 DWG REV: A FOLIO REV: AA 2- Debur and break all sharp edges EXCEPT OTHERWISE NOTED. SEE NOTE 8 ***KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE***

140 - PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

160 - PRIME AS PER DWG AND QSI005, SEE NOTE #2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX*** PRIMER BATCH: 5094268

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	3.8600 ft (.386 ea)	90-Start up Operation	510104

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	4	37	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																																																																			
Description Work Order DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-8200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S124360 Part: D5557-1 Job No: 184523 Serial No/Batch: S124360 Revision: PA7 Inspector: _____ Exp Date: _____ Instructions: Various STC's				Disposition Date: 11/04/18				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																	
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER : _____</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER : _____	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041635**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO041635

PO Date: 11/7/18

Due Date: 11/29/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ** Please confirm pricing and day of delivery **

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184523	D5557-1	Cutter Blade : Various STC's PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	11/29/18	10 pcs	0 pcs	10 pcs	\$26.00/pcs	\$260.00
Grand Total:											\$260.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/22/18 1:31 PM dart.tsimiklis.chrisoula

21
21
21

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
331858	1	132420

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
41635		A2	2018/11/9	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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✓ 10 D5557-1 ✓
(10) D5557-1 JOB 184523 ✓ 3,35

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EMPAQUETAGE Packing	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 10

POIDS EXPÉDIÉ / Weight Shipped : 3,35

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVE

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 10

POIDS EXPÉDIÉ / Weight Shipped : 3,35

Signature:

Date:

APPROVED

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331858	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41635 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

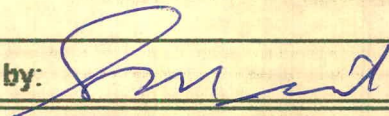
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5 (907)	61 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
✓ 10	3,35	D5557-1 (10) D5557-1 ✓ JOB 184523 ✓ 1 BOITE DE CARTON

23/11/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-11-14

DAS
68
9-89

APPROUVÉ

METCOR INC.

500 BUL. ARTHUR-SAUVE, ST-EUSTACHE, QC J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-2498

Télécopieur / Fax production: 450 491-6424

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
331858	1

CLIENT / customer 218

DART AEROSPACE

1370 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1370 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
41835	N/A	AS		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS

88 - 92 HRC

5

81 - 92 HRC

(907)

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
10	3,38	D557-1 (10) D557-1 - JOB 184523
		1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by	DATE: 2018-11-14
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APPROUVÉ